

Work Order ID 78014

78014

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December-28-11 1:27:46 PM

Item ID: D3286-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 23/12/2011 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 01/02/2012 Req'd Qty: 100.00 ***100*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/12/28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3286	Rev A								

100 0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3286
 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary

0.00

B12-1-4

(109)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

B12-1-4

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

12 01 06 (109)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 23/12/2011 **Start Qty:** 100.00

100

Cust Item ID:

Required Date: 01/02/2012 **Req'd Qty:** 100.00

100

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

130

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Form as per Dwg D3286

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

0.00

150

Identify as per dwg & Stock Location: L 6

0.00

Packaging

Memorandum

Packaging

STOCK IN SKIDTUBE CELL

W/O:		WORK ORDER CHANGES					
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Work Order ID 78014***78014***

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Item ID: D3286-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 23/12/2011 Start Qty: 100.00

100

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/11/12

MF
12-01-12

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 78014

78014

Parent Item: D3286-1

D3286-1

Parent Item Name: Doubler

Start Date: 23/12/2011

Required Date: 01/02/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP A04.07.14New issueKJ/JLM
IPP Rev:B Now on Waterjet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	52.9000	0.0749	7.884211	8.3		
M304S11GA									**	B12-1-4			
304/316 0.125 Sheet													

Location

Loc Qty

Loc Code

MAT020

52.9

119006

30.5

119048

22.4

119006

(109)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

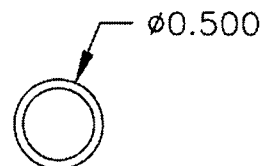
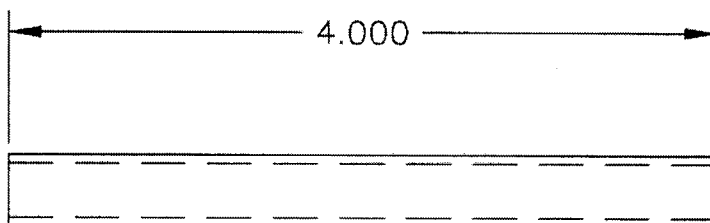
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78/114

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL
(REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.06.22 *#*

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